

## GENERAL NOTES:

### 1. SPECIFICATIONS:

- ALL MATERIAL AND WORKMANSHIP SHALL BE IN ACCORDANCE WITH THE GEORGIA STANDARD SPECIFICATIONS, 2001 EDITION, AS MODIFIED BY CONTRACT DOCUMENTS AND/OR DESIGN DRAWINGS.
- AASHTO/AWS D1.5 "BRIDGE WELDING CODE" CURRENT EDITION.
- DESIGN DATA SPECIFICATIONS: AASHTO 17TH EDITION, 2002.

### 2. MATERIAL:

- MISCELLANEOUS MATERIAL NOTED ASTM A709 GR.36 MAY BE EITHER ASTM A709 GR.36, AASHTO M270 GR.36 OR ASTM A709 GR.50. ALL MATERIAL SHALL BE DOMESTIC.  
MAIN MATERIAL (NEW W36 BEAMS) SHALL BE ASTM A709 GR.50(+H) AS NOTED ON DETAIL SHEETS. ALL MATERIAL SHALL BE DOMESTIC.
- ASTM A108 HEADED SHEAR STUDS SHALL COMPLY WITH AASHTO/AWS D1.5 CHAPTER 7. SHEAR STUDS TO MEET THE MECHANICAL PROPERTY REQUIREMENTS OF TYPE B OF TABLE 7.1. REFERENCE SUB-SECTION 501.3.04.1.3 OF THE GEORGIA 2001 STANDARD SPECIFICATIONS.
- ALL STEEL DESIGNATED THUS (+H) SHALL MEET THE CHARPY V-NOTCH TEST REQUIREMENTS AS SPECIFIED BY SECTION 851 OF THE GEORGIA 2001 STANDARD SPECIFICATIONS USING THE H FREQUENCY OF TESTING.

### 3. FABRICATION AND WORKMANSHIP:

- CLIP CORNERS OF ALL GUSSET (CONNECTION) PLATES AS NOTED ON DETAIL SHEETS. TERMINATE WELDS AS SHOWN IN THE WELD TERMINATION DETAIL ON THIS SHEET.
- ALL RE-ENTRANT CUTS SHALL HAVE A MINIMUM RADIUS OF  $\frac{3}{4}$ " UNLESS NOTED.
- THE WEIGHTS SHOWN ON DETAIL SHEETS ARE GROSS WEIGHTS.
- ALL STUB DIMENSIONS FOR GUSSET (CONNECTION) PLATES ON BEAM DETAIL SHEETS ARE TAKEN FROM THE CL OF BEARING AT THE LEFT END OF THE BEAM OR FROM A WORK LINE 1'-0" TO THE RIGHT OF THE WELDED FIELD SPLICE.
- MARK WEIGHT OF THE BEAM DIRECTLY UNDER THE SHIPPING MARK.
- HEAT NUMBERS SHALL BE PRESERVED AND LEFT VISIBLE FOR INSPECTION.
- THE BOTTOM FLANGES OF THE BEAMS AT THE BEARING LOCATIONS SHALL BE SHOP STRAIGHTENED AS NECESSARY TO PROVIDE A UNIFORM CONTACT BETWEEN THE BEAM'S BEARING COMPONENTS AND THE BRIDGE SEAT (BENT CAP).
- SURFACES IN CONTACT WITH SELF-LUBRICATING BRONZE PLATES SHALL NOT BE PAINTED AND SHALL BE CLEANED AND THEN COATED WITH BRONZE PLATE MANUFACTURER'S LUBRICANT.
- SEE SHEET W1 FOR FIELD SPLICE AND SHOP SPLICE FABRICATION DETAILS INCLUDING COPE HOLES AT THE SPLICED ENDS OF BEAMS. DO NOT PAINT WITHIN 9" MINIMUM FROM FIELD SPLICE ENDS OF ALL BEAMS.

### 4. WELDING:

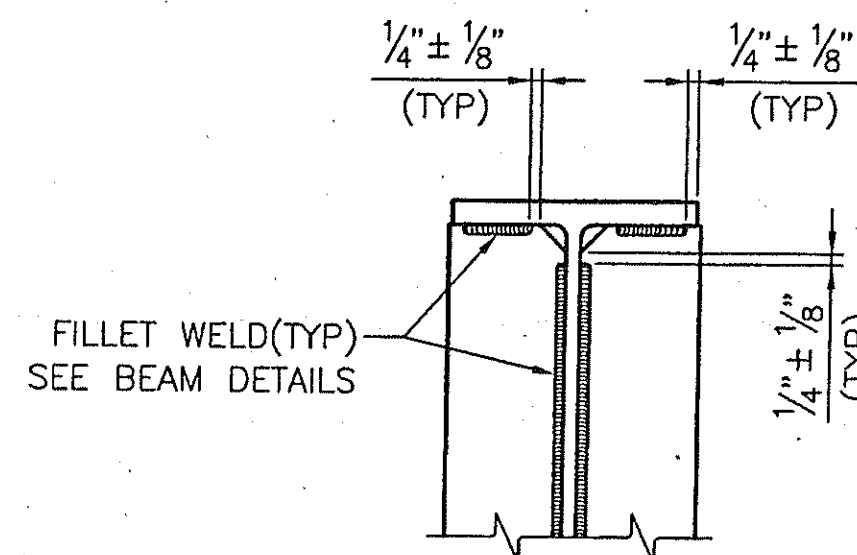
- WELDING AND WELD EXAMINATIONS SHALL BE IN ACCORDANCE WITH THE CURRENT AASHTO/AWS D1.5 "BRIDGE WELDING CODE" AND WITH THE GEORGIA 2001 STANDARD SPECIFICATIONS SUB-SECTIONS 501.3.04.H AND 501.3.06.C.
- ALL WELDING SHALL BE PERFORMED BY CERTIFIED WELDERS THAT HAVE IN THEIR POSSESSION A CURRENT WELDING CERTIFICATION CARD ISSUED BY THE GEORGIA DOT OFFICE OF MATERIALS AND RESEARCH. USE ONLY E70XX (EXCLUDING E7014 AND E7024) LOW HYDROGEN ELECTRODES FOR MANUAL SHIELDED METAL ARC WELDING.
- TERMINATE GUSSET (CONNECTION) PLATE TO WEB WELDS  $\frac{1}{4}$ " ( $\pm \frac{1}{8}$ ") FROM CLIPPED CORNERS. TERMINATE GUSSET PLATE TO FLANGE WELDS  $\frac{1}{4}$ " ( $\pm \frac{1}{8}$ ") FROM CLIPPED CORNERS AND FLANGE EDGE. SEE WELD TERMINATION THIS SHEET.

### 5. CLEANING AND PAINTING:

- ALL STRUCTURAL STEEL SHALL BE THOROUGHLY CLEANED IN ACCORDANCE WITH STEEL STRUCTURES PAINTING COUNCIL SPECIFICATION SSPC-SP6, "COMMERCIAL BLAST CLEANING".
- ALL STRUCTURAL STEEL EDGES TO BE PAINTED OR EDGES NOT ENCASED IN CONCRETE SHALL RECEIVE LIGHT GRINDING TO A RADIUS OF APPROXIMATELY  $\frac{1}{16}$ " OR A SUITABLE CHAMFER.
- SHOP AND FIELD CONTACT (FAYING) SURFACES SHALL NOT BE PAINTED.
- ALL CLEANED STRUCTURAL STEEL SHALL RECEIVE ONE (1) SHOP COAT OF BROWN PRIMER WITH A MINIMUM DRY FILM THICKNESS OF 3.0 TO 5.0 MILS
  - SHOP PAINTING SHALL BE PER SYSTEM VI (WATERBORNE) OF THE GEORGIA 2001 STANDARD SPECIFICATIONS SECTION 535 - PAINTING STRUCTURES.
  - PAINT MATERIALS SHALL BE PER THE GEORGIA 2001 STANDARD SPECIFICATIONS SECTION 870 - PAINT.
  - THE NO PAINT AREAS ON DETAILS ARE DIMENSIONED 1"  $\pm$  BEYOND CONCRETE CONTACT SURFACES AND AREAS ADJACENT TO FIELD WELDS. DO NOT PAINT WITHIN 9" MINIMUM FROM THE FIELD SPLICE ENDS OF ALL BEAMS.

#### PAINT ABBREVIATIONS ON DETAIL SHEETS:

- NPA ~ NO PAINT ALL AROUND  
NPBS ~ NO PAINT BOTH SIDES  
NPNS ~ NO PAINT NEAR SIDE  
NPFS ~ NO PAINT FAR SIDE



GUSSET (CONN.) PLATES  
TOP FLANGE SHOWN,  
BTM FLANGE SIMILAR.

### WELD TERMINATION DETAIL

### STANDARD ABBREVIATIONS

- AISW ~ AUGUSTA IRON & STEEL WORKS, INC.  
BTM ~ BOTTOM  
BRG ~ BEARING  
CL ~ CENTER LINE  
CJP ~ COMPLETE JOINT PENETRATION  
CLR ~ CLEARANCE  
DOR ~ DIRECTION OF MILL ROLLING  
FLG ~ FLANGE  
(FS) ~ FAR SIDE  
GDR ~ GIRDER  
(NS) ~ NEAR SIDE  
NPA ~ NO PAINT ALL AROUND  
NPBS ~ NO PAINT BOTH SIDES  
NPFS ~ NO PAINT FAR SIDE  
NPNS ~ NO PAINT NEAR SIDE  
PL ~ PLATE  
TYP ~ TYPICAL  
U.N. ~ UNLESS NOTED  
MP ~ MAGNETIC-PARTICLE WELD TESTING  
RT ~ RADIOGRAPHIC NONDESTRUCTIVE WELD EXAMINATION  
UT ~ ULTRASONIC NONDESTRUCTIVE WELD EXAMINATION  
VT ~ VISUAL WELD EXAMINATION  
WP ~ WORK POINT

DATE: NOV 05 2012

Approved in general. Details not checked. This approval shall not relieve the Contractor of any responsibility for conformity with the contract Plans and Specifications.

Georgia DOT  
Office of Bridge Design


By: JTM

APPROVED IN GENERAL, DETAILS NOT CHECKED. THIS APPROVAL SHALL NOT RELIEVE THE CONTRACTOR OF ANY RESPONSIBILITY FOR CONFORMITY WITH THE CONTRACT PLANS AND SPECIFICATIONS.


AECOM TECHNICAL SERVICES, INC.

BY:

*[Signature]*

FIELD BOLTS 3/4" A307	
OPEN HOLES AS NOTED	
TYPE WELDING L.H. RODS OR SUBMERGED ARC	

**AUGUSTA IRON & STEEL WORKS, Inc.**  
P.O. BOX 212479 (30917) Phone: 706-860-7719  
3781 MARTINEZ BLVD. AUGUSTA, GA 30907

		SUBMITTED ARC			
		<b>AUGUSTA IRON &amp; STEEL WORKS, Inc.</b>			
		P.O. BOX 212479 (30917)		Phone /706-860-7711	
		3781 MARTINEZ BLVD.		AUGUSTA, GA 30906	
					
		GENERAL NOTES			
		CUSTOMER: C.W. MATTHEWS CONTRACTING CO.			
		WIDENING SR 1/US 27 OVER SR 166			
		BRIDGE No. 1 LEFT & RIGHT			
		GDOT PROJECT NO. NH000-0017-01(022)			
		CARROLL COUNTY, GEORGIA			
		DESIGNED BY: AECOM			
		DRAWN BY: JWW		DATE: 10/2011	
		CHECKED BY: AISW		DATE: 10/2011	
		STEEL SPEC: SEE NOTE 2.			
△		△		△	
REV.		BY		DATE	
REVISION		DESCRIPTION			